

1    WHAT IS CLAIMED IS:

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3    ✓. The hydroprocessing method of the instant invention, which has at least two  
4       reaction stages, comprises the following steps:

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6       (a) passing a hydrocarbon feed into a first reaction stage, which is  
7           maintained at hydroprocessing conditions, where it is contacted with a  
8           catalyst in a fixed bed and at least a portion of the feed is converted;

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10      (b) combining the effluent of step (a) with product material from the  
11           second reactor stage and passing the combined stream to a  
12           separation zone;

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14      (c) separating the stream of step (b) into an unconverted liquid effluent  
15           and at least one converted stream comprising products having a  
16           boiling point below that of the feed;

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18      (d) passing the unconverted liquid effluent from step (c) to a second  
19           reaction stage, said stage comprising a plurality of reaction zones,  
20           wherein each zone is maintained at hydrocracking conditions and  
21           separation occurs between each zone;

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23      (e) contacting the feed in the first reaction zone of step (d) with a catalyst  
24           in a fixed bed, thereby converting at least a portion of the feed;

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26      (f) separating the effluent of step (e) into an unconverted liquid effluent,  
27           and a hydrogen-rich converted stream;

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29      (g) recycling the hydrogen-rich converted stream of step (f) to combine  
30           with the effluent of step (a);

1           (h) passing the unconverted liquid effluent from step (f) to a second  
2           reaction zone of the second stage, the zone being maintained at  
3           hydrocracking conditions;

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5           (i) contacting the feed in the second reaction zone of step (h) with a  
6           catalyst in a fixed bed, thereby converting at least a portion of the  
7           feed;

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9           (j) fractionating the effluent of step (i) to produce gas, naphtha, and one  
10          or more middle distillate product streams, unconverted material being  
11          recycled to step (d).

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13        2. The process of claim 1(d), wherein the inlet temperature of each reaction  
14          zone in the second stage subsequent to the first reaction zone is lower than  
15          the previous one and the outlet temperature of each reaction zone  
16          subsequent to the first reaction zone is lower than the previous one.

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18        3. The process of claim 2, wherein the average reaction temperature of each  
19          reaction zone subsequent to the first reaction zone is at least 50°F lower  
20          than the average reaction temperature of the previous one.

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22        4. The process of claim 1, wherein the catalyst of each reaction zone of the  
23          second stage of step (d) is a hydrocracking catalyst.

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25        5. The process of claim 4, wherein each of the reaction zones of the second  
26          stage is operated under hydrocracking conditions including temperatures in  
27          the range from about 400-950°F (204-510°C), reaction pressure in the  
28          range from 500 through 5000 psig (3.5-34.5 MPa), LHSV of 0.1 to 15 hr<sup>-1</sup>,  
29          and hydrogen consumption of 500 through 2500 scf per barrel of liquid  
30          hydrocarbon feed (89.1-445 m<sup>3</sup> H<sub>2</sub> feed).

1   6. The process of claim 5, wherein more preferred hydrocracking conditions  
2   include a temperature range from 650-850°F (343°C-454°C), reaction  
3   pressure from 1500 psig through 3500 psig (10.4-24.2 MPa) and LHSV  
4   0.25 through 2.5 hr<sup>-1</sup>, and hydrogen consumption of 500 through 2500 scf  
5   per barrel of liquid hydrocarbon feed (89.1-445 m<sup>3</sup> H<sub>2</sub> feed).

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7   7. The process of claim 1, wherein the unconverted effluent comprises  
8   hydrocarbons which boil above 700°F.

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10   8. The process of claim 1, wherein the converted stream comprises  
11   hydrocarbons boiling below 700°F.

12   9. The process of claim 1, wherein the overall hydrocarbon conversion is at  
13   least 60% and the hydrocarbon conversion for each reaction zone is in the  
14   range from 20% to 40%.

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16   10. The process of claim 1, wherein the converted stream from each reaction  
17   zone is continuously combined and fractionated into at least one fuel  
18   product.

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20   11. The process of claim 10, wherein the preferred fuel product is diesel.

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22   12. The process of claim 10, wherein the preferred fuel product is jet fuel.

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24   13. The process of claim 10, wherein the preferred fuel product is naphtha.

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26   14. The process of claim 1, wherein the feed is subjected to a preliminary  
27   hydrotreating step.